

Date: Tuesday, 10/30/2007 2:49:08 PM
 User: Kim Johnson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIN ASSEMBLY
Job Number : 35442	
Estimate Number : 11341	
P.O. Number : N/A	Part Number : D3332043
This Issue : 10/30/2007 S.O. No. : N/A	Drawing Number : D3332 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : MA	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Type : LARGE FAB ASSY	Due Date : 11/15/2007
Written By : <u> </u>	Qty: 10 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: A 05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018R0500	1018-1025 Steel Bar
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Comment: Qty.: 0.1749 f(s)/Unit Total : 1.0496 f(s)
 1018-1025 Steel Bar
 Material: AISI 1018-1025 Ø0.500" Round Bar
 (M1018-R0.500)
 Identify for D3332-7
 Batch: M16634 DJP 07/11/06

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 Machine D3332-7 as per Folio FA493 and Dwg D3332

DJP 07/11/06 (10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/11/06 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JML 07/11/07 (10)

5.0	M1018R0313	1018-1025 Steel Bar
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Comment: Qty.: 0.2836 f(s)/Unit Total : 1.7016 f(s)
 1018-1025 Steel Bar
 Material: AISI 1018-1025 Ø0.313" Round Bar
 (M1018-R0.313)
 Identify as D3332-9
 Batch: M16634

JL 07/12/06 (5X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/12/11	#1.0	Proc (5) parts are status under D3332-7 B# 35442	JG	07/12/11	5x		07/12/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:49:09 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 35442

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Fabricate D3332-9 as per Dwg D3332

07/12/06

5x

7.0

D33321

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Handle Assembly

Pick:

Qty Part Number Description Batch

1 D3332-1 Handle

A/R N/A

Steel Rod

Identify as D3332-043

B35489
4100372

07/12/06

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld using D3332-041T1 as per Dwg D3332

07/12/06

9.0

QC5 / QC9

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QC9 -> PD 07-12-07
QC5 -> 07/12/07

15

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Cover thread only for D3332-9 prior to painting

M 180 52

07/12/07

5x

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-12-07

6.

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51490

07/12/07

07/12/07

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:49:09 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 35442

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/21/10

Job Completion



U. [Signature]
2002/12/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

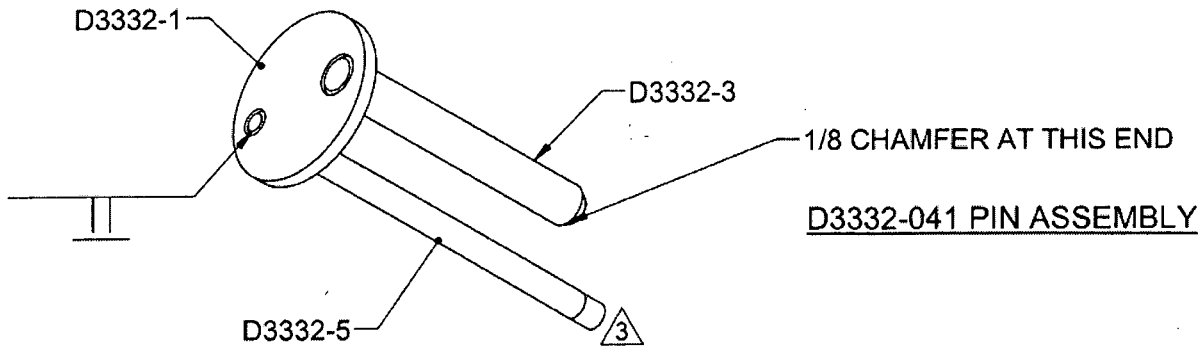
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

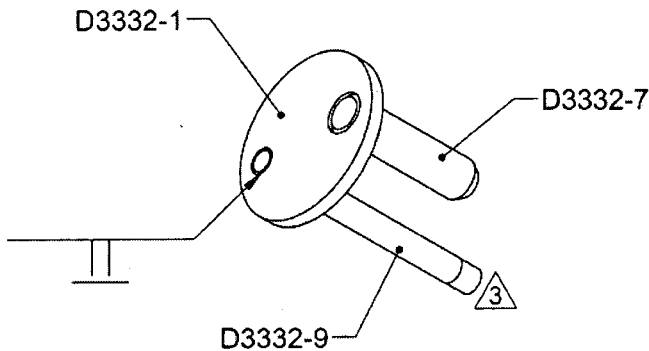


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE $+0.000$ -0.005	



D3332-041 PIN ASSEMBLY

RELEASED
[Signature]
05/02/09



D3332-043 PIN ASSEMBLY

NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

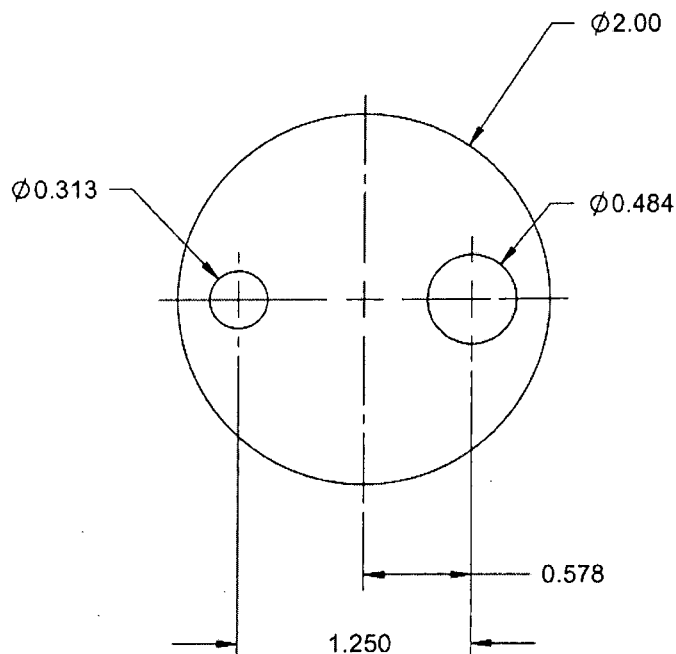
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



RELEASED
[Signature]
5/10/09

D3332-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

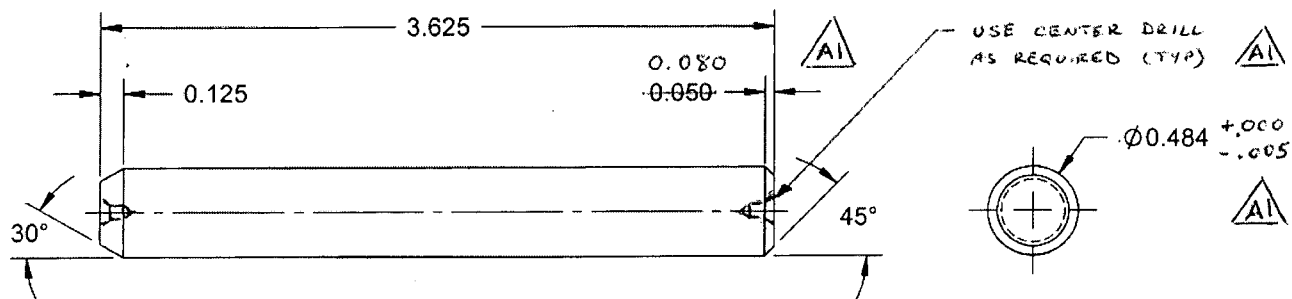
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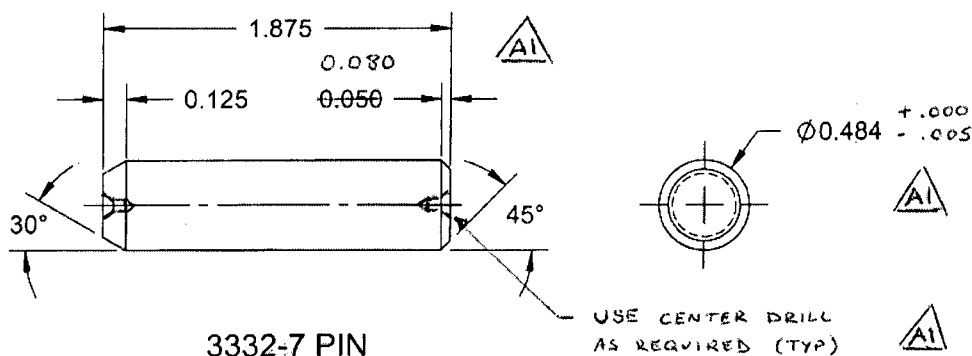


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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN

RELEASED
[Signature]
05/02/09



3332-7 PIN

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

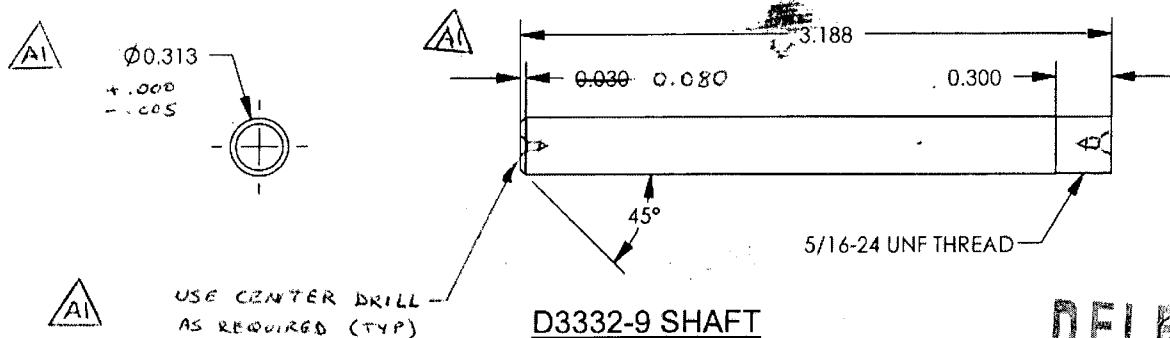
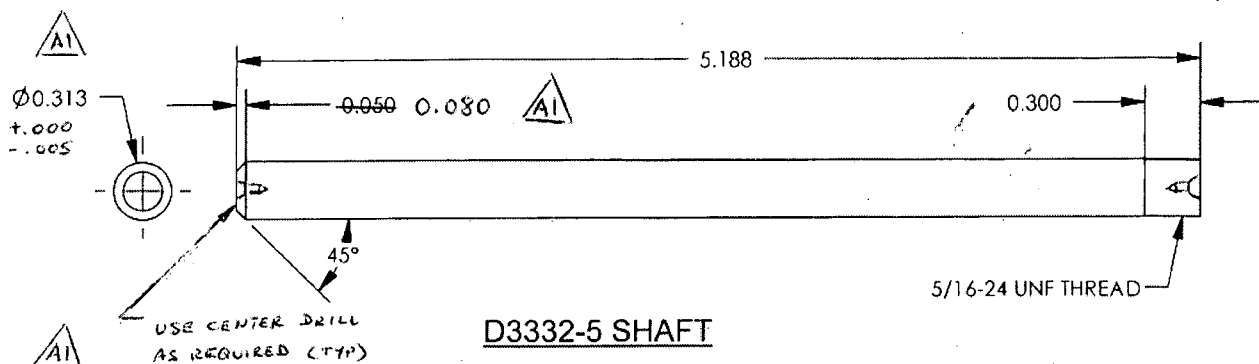
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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$$\begin{aligned} \frac{0.125}{0.22} &= \tan 30^\circ \\ 0.57 &= \tan 30^\circ \\ 0.143 &= \tan 30^\circ \\ 0.357 &= \tan 30^\circ \end{aligned}$$

Sol Cal Top

